

Customer	:	CU-DAR001 Dart Helicopters Services	Drawing Name	:	BEARPAW KIT (19"x24")	
Job Number	:	30801				
Estimate Number	:	10323				
P.O. Number	:	N/A	Part Number	:	D206559013	
This Issue	:	2/22/2007	S.O. No.	:	N/A	
Prsht Rev.	:	NC	Drawing Number	:	D2432 REV F3	
First Issue	:	N/A	Project Number	:	N/A	
Previous Run	:	30340	Drawing Revision	:	F3	
		Type :	MACHINED PARTS	Material	:	N/A
Written By	:			Due Date	:	3/13/2007
Checked & Approved By	:	07.02.23		Qty:		8-6 Each
Comment	:	Est Rev:J 04.02.17 Blank size changed KJ/JLM				
		Est Rev:K 07-01-02 Was K10008 JLM				

Job Number:



Seq. #:	Machine Or Operation:	Description :
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10 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-559-013 CHG005 2 07.03.01

20	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 6.8250 sf(s)/Unit Total: 34.1250 sf(s)
blank: 19.500" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5
Material: Black UHMW 1"
(MUHMWB10)
Batch: 9103975

30 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Note:(2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2432 Identify as D2432F

3-Deburr

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 2:53:51 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X24")

Job Number: 30801

Part Number: D206559013

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SD 01-04-09

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 2.5000 f(s)/Unit Total : 12.5000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2182B050 Rubber Cushion

B30397 ✓

8.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274 Radius Block

2 D2432F(ref only) Bearpaw

B30518 ✓

B30801

9.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2438 Clamp

B30381 ✓

10.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2529 Washer

B30382 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 2:53:51 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X24")

Job Number: 30801

Part Number: D206559013

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2732

Rubber Extrusion



Comment: Qty.: 0.4166 f(s)/Unit Total : 2.0830 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2732-050 Rubber Cushion B26472 ✓

12.0

AN415A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : ~~60.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-15A Bolt M103585 ✓

13.0

AN417A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : ~~60.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-17A Bolt M102280 ✓

14.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : ~~120.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416 Washer M102929 ✓

15.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : ~~60.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4 Nut (or -4) M103914 ✓

CP 4/04/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: ED Date: 07/04/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 2:53:51 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X24")

Job Number: 30801

Part Number: D206559013

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD206-559-013

Location: NEVA

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 7-10-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	30801
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 Rev: F3		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.055x45°	—			
B	5.500	+/-0.030	5.497	—			
C	0.200	+/-0.030	0.205	—			
D	0.25 x 45°	+/-0.030	0.259x45°	—			
E	R0.250	+/-0.030	R0.250	—			
F	0.250	+/-0.010	0.243	—			
G	0.625	+/-0.030	0.605	—			
H	0.375	+/-0.010	0.371	—			
I	0.950	+0.030/0.010	0.951	✓			
J	19.000	+/-0.030	19.000	—			
K	3.14	+/-0.030	3.130	—			
L	3.28	+/-0.030	3.290	—			
M	Ø0.260	+0.005/-0.000	Ø0.260	—			
N	Ø0.93	+/-0.030	Ø0.928	—			
O	0.30	+0.030/-0.000	0.310	—			
P	23.750	+/-0.030	23.750	—			
Q	7.375	+/-0.030	7.375	—			
R	4.250	+/-0.010	4.250	—			
S	2.000	+/-0.030	2.000	—			
T	9.000	+/-0.010	9.000	—			
U	9.000	+/-0.010	9.000	—			
V	0.375	+/-0.010	0.381	—			

Measured by: <i>gmk</i>	Audited by: <i>SC</i>	Prototype Approval:	N/A
Date: 07/04/01	Date: 07.04.01	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O K10008/D206-559-015	KJ/RF <i>[Signature]</i>	<i>[Signature]</i>



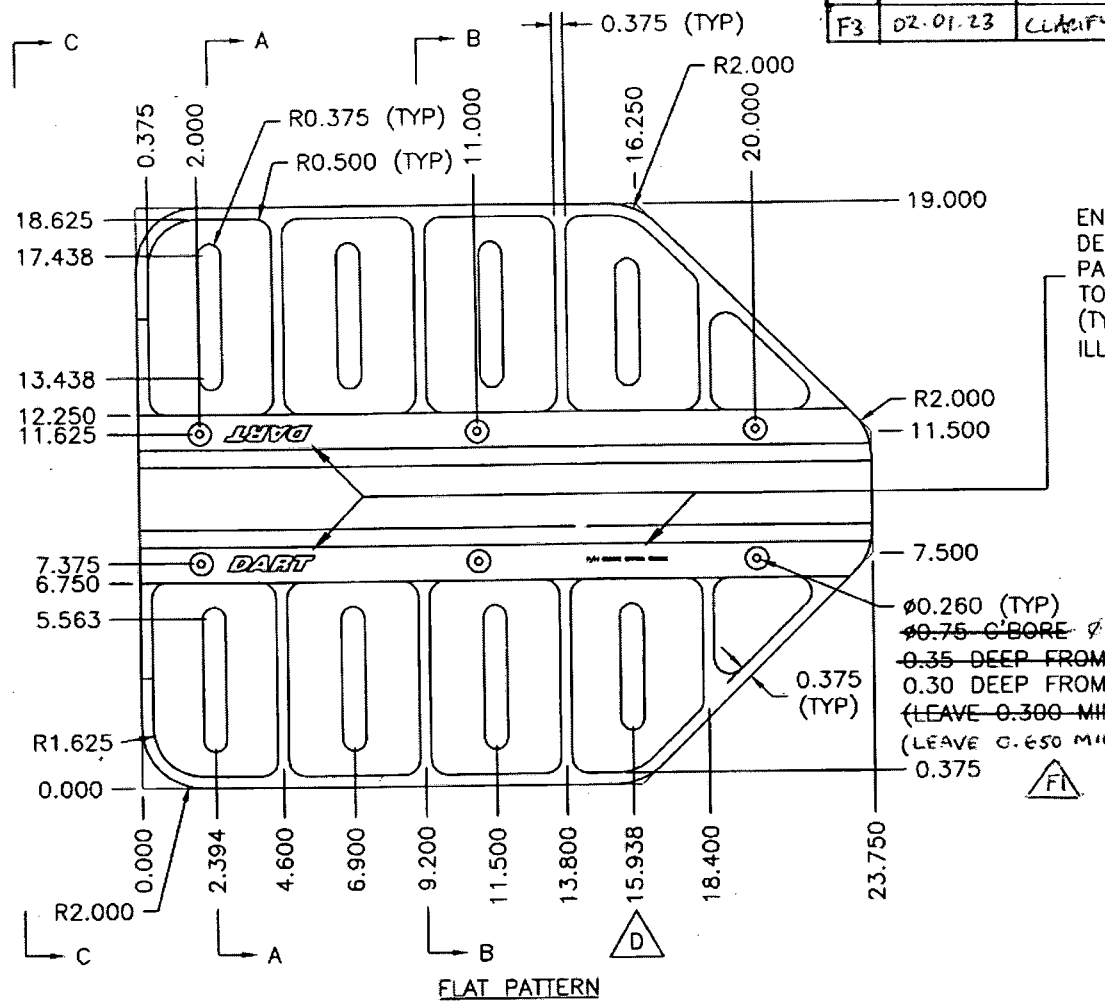
RELEASED
98.06.17 KES

F1	99.03.03	ADD DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 RF
F3	02.01.23	CLARIFY BORE DIMS RF

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
KE	KE		
CHECKED	APPROVED	DRAWING NO.	REV. F
MM	JS	D2432	SHEET 1 OF 2
DATE		TITLE	SCALE
98.05.12		BEARPAW	1:6
A	95.10.31	NEW ISSUE	
B	96.01.24	RE-DESIGN	
C	96.03.26	CHANGE BORE AND C'BORE DEPTH	
D	96.06.04	MOVE SLOT	
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS	
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N	

EFFECTIVE	DEOS
9143	



D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

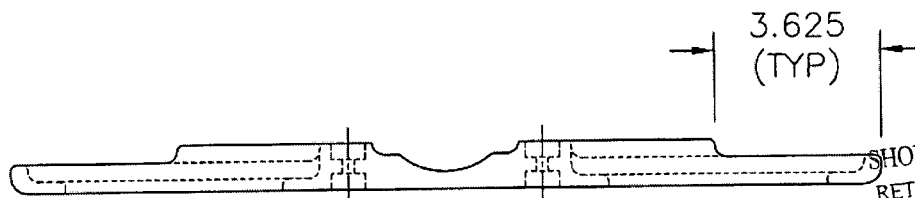
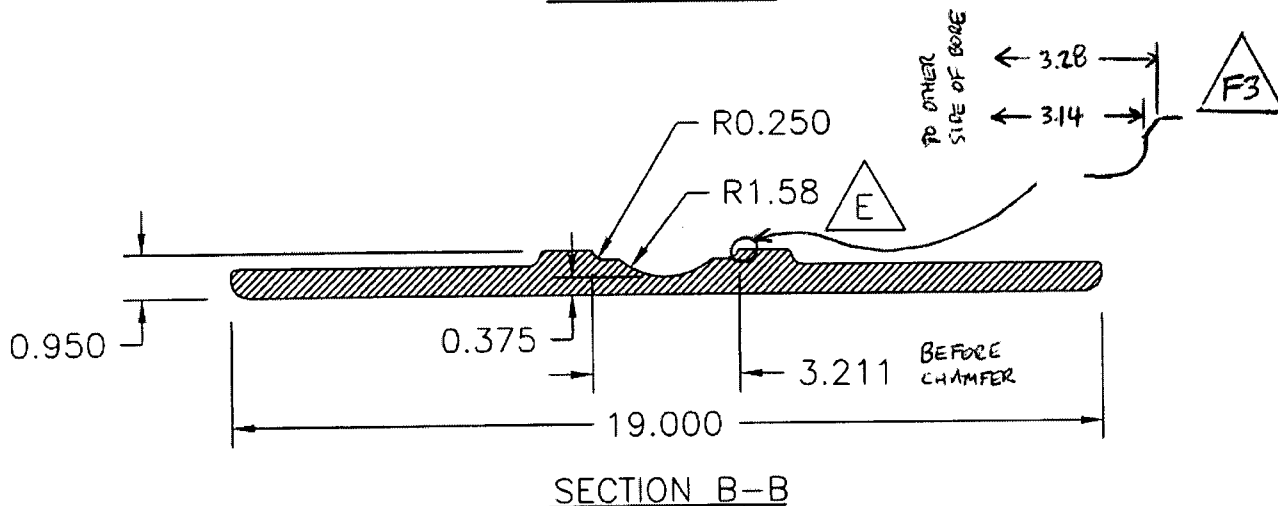
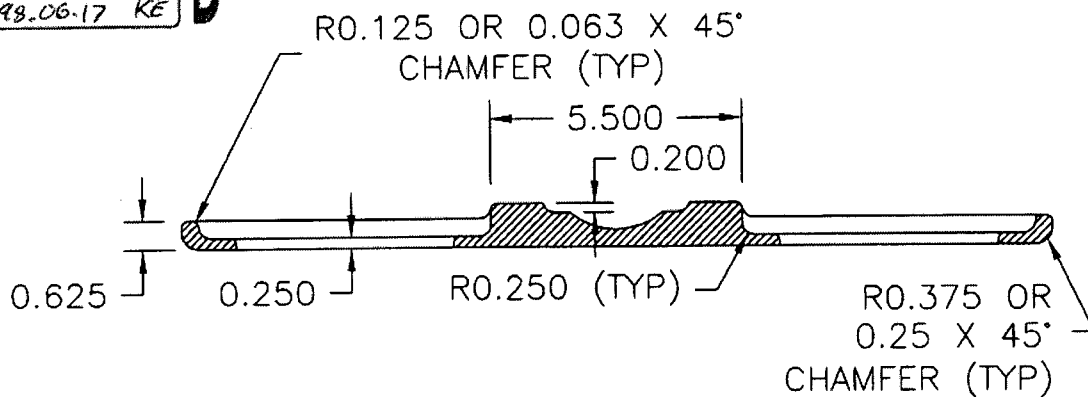
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NO. 30801
WORK ORDER
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SHOP CODE
WITHOUT NOTICE



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

RELEASED
98.06.17 KE



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